

Date: Friday, 22/08/2008 2:02:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 41600	Part Number	: D34611
Estimate Number	: 11418	Drawing Number	: D3461 REV.A
P.O. Number	:	Project Number	: N/A
This Issue	: 22/08/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 28/08/2008 Qty: 20 Um: Each
Previous Run	: 33070		
Written By	:		
Checked & Approved By	: <u>JUL 08.8.22</u>		
Comment	: est. REV. A 05.12.13 NEW ISSUE EC Est Rev:B Now on Waterjet 07-06-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00
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Comment: Qty.: 0.1785 f(s)/Unit Total: 3.5700 f(s)

ALUMINUM 6061-T6 Bar .188" x 4.0"

Batch: 109997 IB 8-9-10

2.0	WATER JET <u>105997</u>	FLOW WATER JET
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(P107)

Comment: FLOW WATER JET

1-Cut as per Dwg D3461

Dwg Rev: AProg Rev: AIB 8-9-10

(21)

2-Deburr if necessary

6/9/17 sd CP

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-9-10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/09/02 (420)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr parts per dwg D3461

u/a Done at step #2.25 06/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3461-1 PAR #: N/A Fault Category: Prod/Prod. Ass' med & small. NCR: Yes No DQA: D Date: 08/09/25
D2721-044042 D206-628-011/012
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 08/09/25

NCR: <u>41600</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/9/22</u>	<u>1/2</u>	<u>one part scrap - found</u> <u>During Deburring, to</u> <u>have a small peeling from</u> <u>the welds set next to</u>	<u>[Signature]</u>	<u>Scrap and Destroy</u> <u>no replace qty @</u> <u>one extra made.</u>	<u>B</u> <u>8-9-22</u>	<u>S</u> <u>08/09/22</u>	<u>[Signature]</u>	<u>S</u> <u>08/09/22</u>
		<u>the 257" hole</u> <u>R.C. Machine mal function.</u>	<u>[Signature]</u>				<u>[Signature]</u>	

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 41600

Part Number: D34611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/02/02 (F20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST96*

JS 08/09/23 (K29)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/24 JF

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

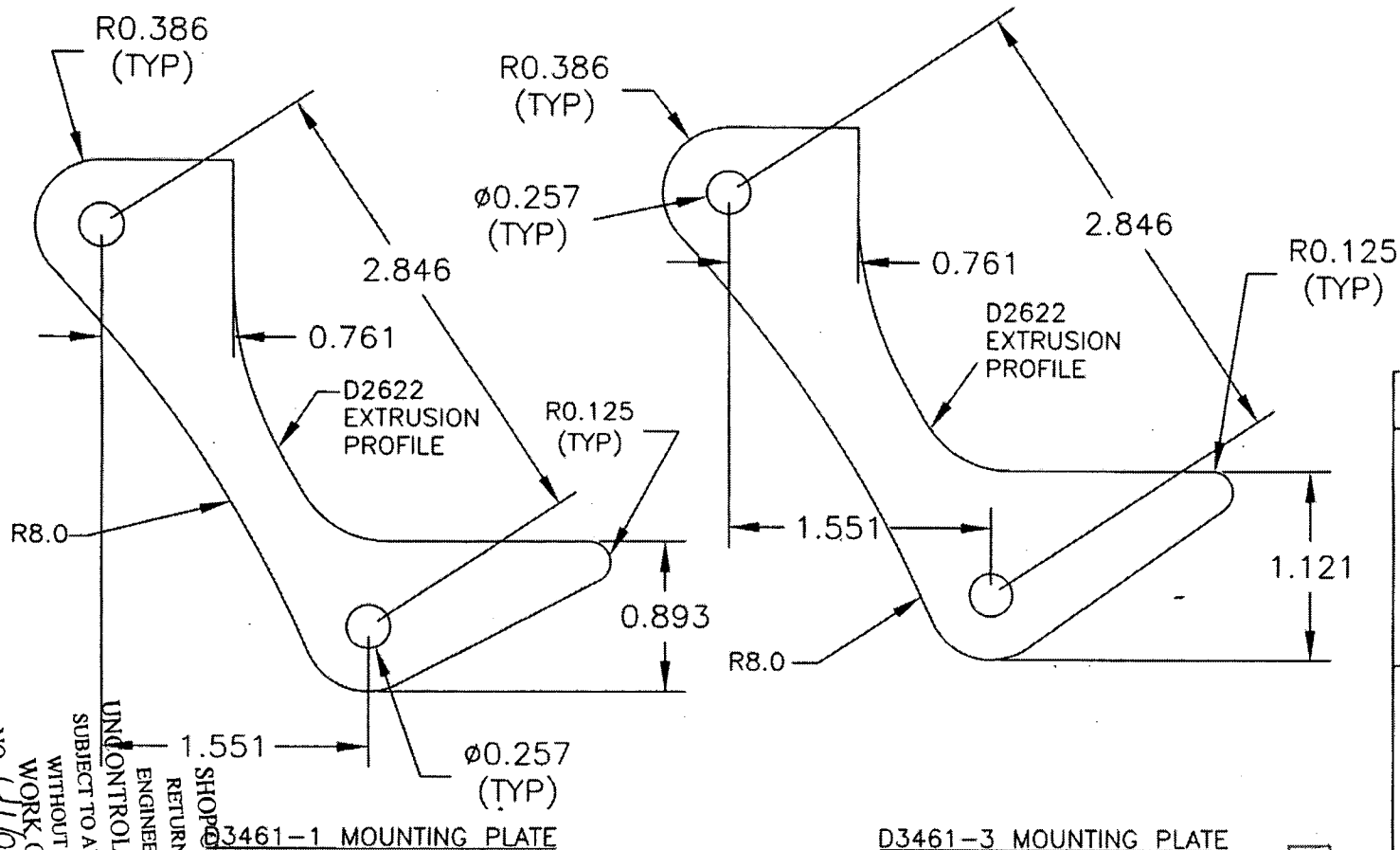
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3461	SHEET 1 OF 2
DATE		TITLE	SCALE
05.09.19		STEP MOUNTING PLATE	1:1
A	05.09.19	NEW ISSUE	

RELEASED
05/11/14



D3461-1/-3 MOUNTING PLATE

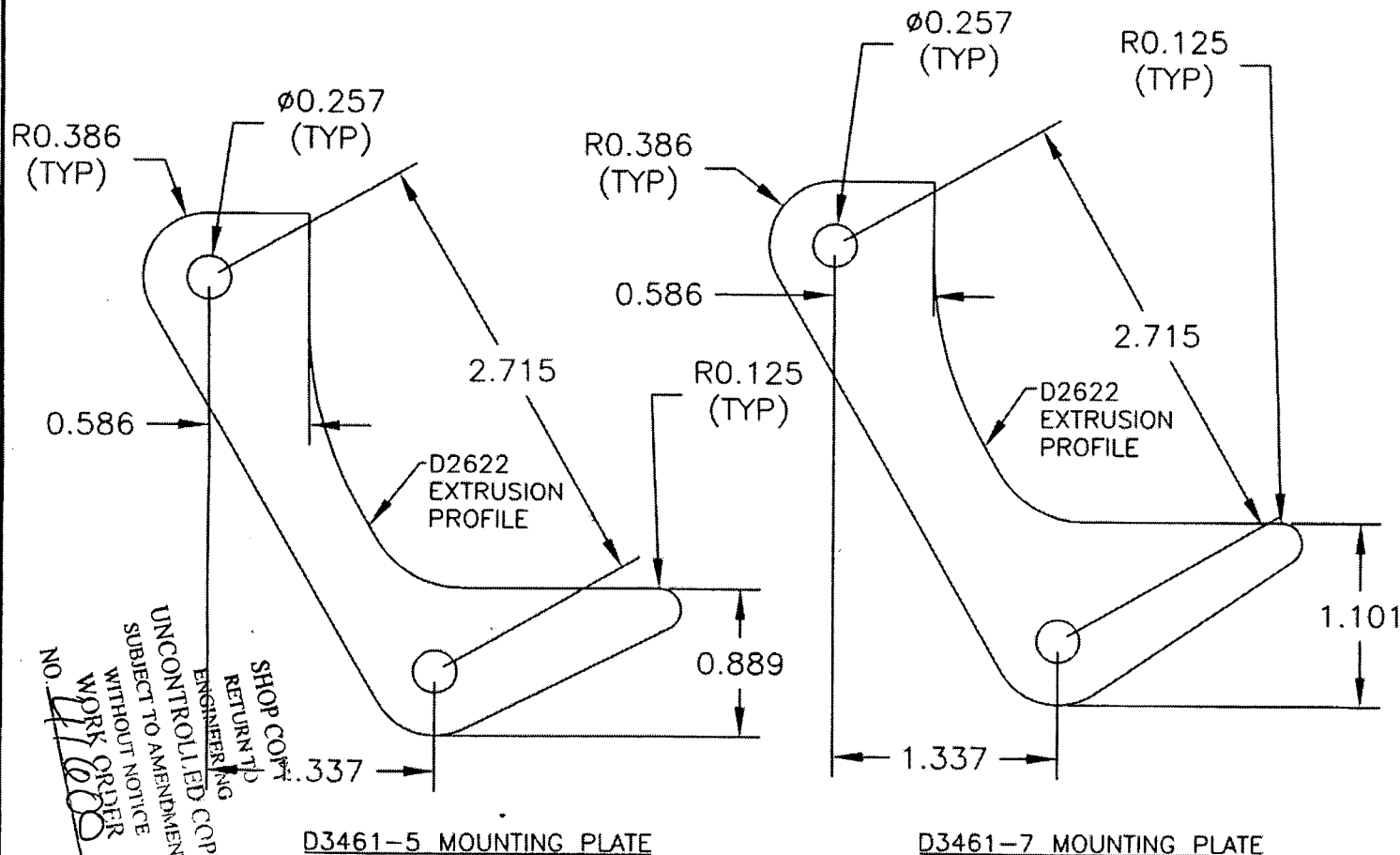
- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 41600
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. A
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3461	SHEET 2 OF 2
DATE	05.09.19	TITLE	STEP MOUNTING PLATE	SCALE	1:1	

RELEASED
05/11/14



D3461-5/-7 MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 47000

